

Date: Friday, 5/25/2007 8:26:21 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE SPACER
Job Number : 32628	
Estimate Number : 11062	
P.O. Number : N/A	Part Number : D2934
This Issue : 5/25/2007 S.O. No. : N/A	Drawing Number : D2934 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 31929	Material : N/A
Written By : <u>07.05.28</u>	Due Date : 6/6/2007 Qty: 40 Um: Each
Checked & Approved By : <u>07.05.28</u>	
Comment : Est A 00-06-06 New Issue EC	
Est Rev:B Now 6061-T6 06-06-23 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.0334 sf(s)/Unit Total : 1.3356 sf(s)

Material: 6061-T6 0.080" Thick

Batch M104392ml 07 06 10(40)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2934

Dwg Rev: BProg Rev: Bml 07 06 10(40)

2-Deburr if necessary

SAD 07/06/23 (40) counted

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07 06 10(40)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Er 07/06/18 (40)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

07-06-28 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: FD Date: 07/06/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:26:21 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 32628

Part Number: D2934

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Ep 07/06/29 (40)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Ep 07/06/29 (40)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Ep 07/06/29 (40)

Job Completion



U 07-06-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

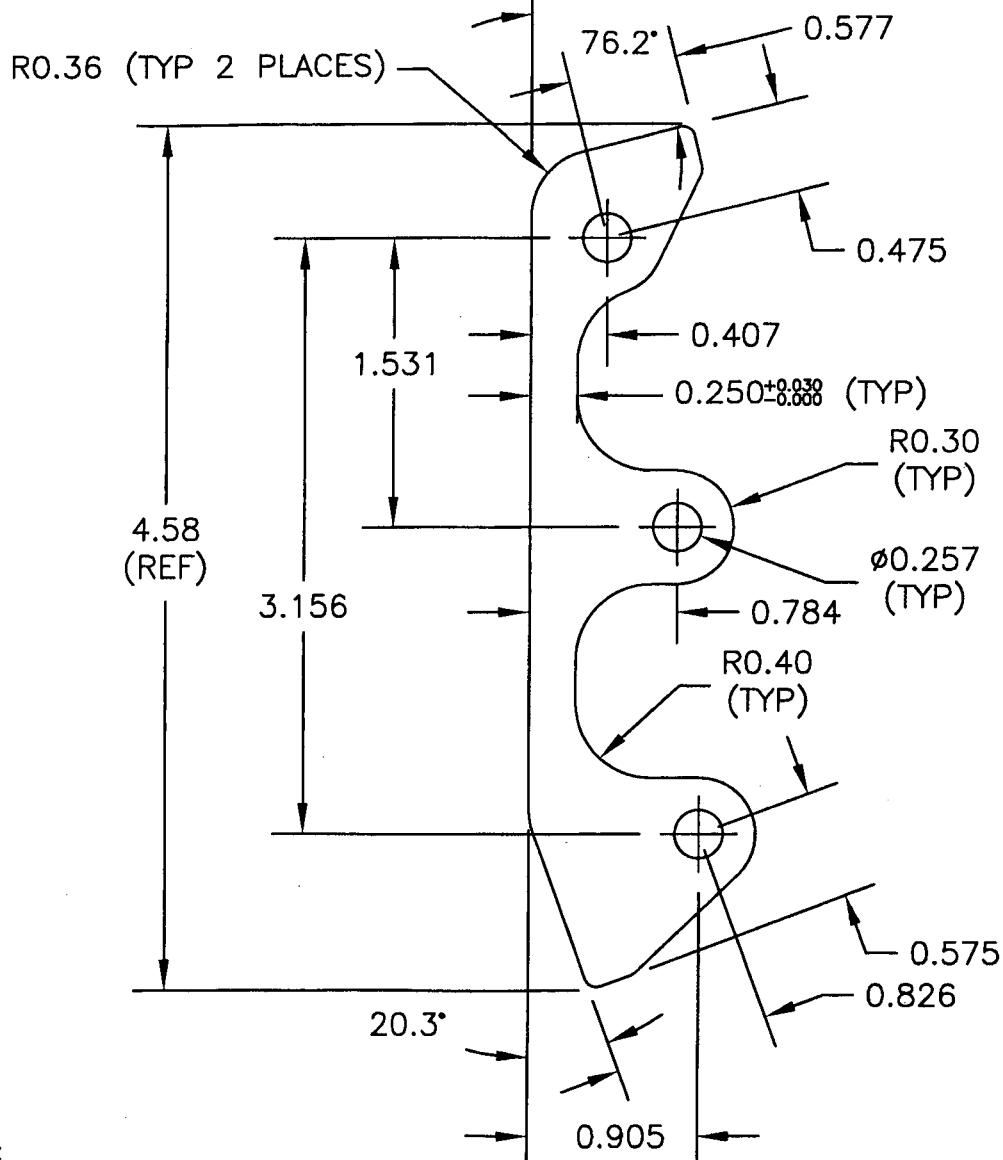
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #4	DRAWN BY C.B.	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2934	REV. B SHEET 1 OF 1
DATE 06.05.29	TITLE SADDLE SPACER		SCALE 1:1
A	99.11.02	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

**RELEASED**

06.06.20 [Signature]

NOTES:

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK
(REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32628

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DART AEROSPACE LTD		Work Order: 32628
Description: Saddle Spacer		Part Number: D2934
Inspection Dwg: D2934 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 0.251$	+0.006-0.001	0.260	✓		VWN	
B 4.58	+/-0.030	4.56	✓		VWN	
C 3.156	+/-0.010	3.160	✓		Height Gauge	
D 1.531	+/-0.010	1.536	✓		Height Gauge	
E 0.250	+/-0.010	0.260	✓		VWN	
F R0.30	+/-0.030	R0.30	✓		VWN	
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: ML ML	Audited by: <i>ES</i>	Prototype Approval: N/A
Date: 070610	Date: 07/06/08	Date: N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	